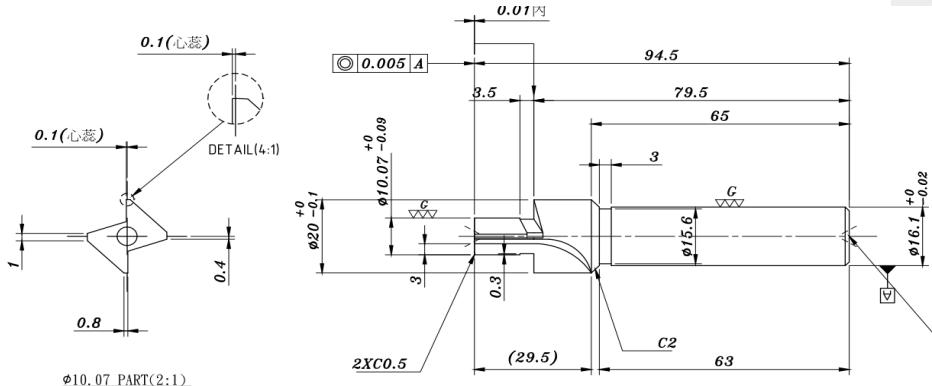


## Stepreamer Ø10.07-Ø20

### A15-200

This tool is basically not a finished tool, it is the shank before soldering of PKD inserts. The OD grinding was done before on a cylindrical grinding machine.



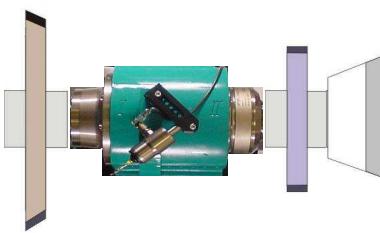
### 1. Cycletime for Production

Workpiece:	end-Ø10.07-Ø20, shank-Ø16.1 mm, Z 2, Length 29 mm, Helix angle 0° Material CARBIDE					
Operations	Probe	Flute 1	Flute 2	O.D.2	O.D.1	Special Step
Feed [mm/Min]	2000	15	20	30	60	50
Power [kW]		2	1	1	1	1
Cutting speed [m/s]		20	20	22	22	22
Used wheels		1	1	2	3	3
Grinding time [s]	9	268	198	82	46	450
Total cycle time	17 Min 34					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	1A1 Ø100 D76
2	11V9 Ø100 D76
3	1V1 Ø125 D76



3

1 2

### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 31iA5

Software: Quinto 5

Accessories:

Responsible engineer: OP. 28.2.13

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